

Work Order ID 51261

August 13, 2009 8:04:23 AM



Page 1

Item ID: D3508-1	Accept		Setup Start	
Revision ID: C			Stop	
Item Name: Wearplate				
Start Date: 08/13/2009 Start Qty: 12.00		Cust Item ID:		
Required Date: 08/28/2009 Req'd Qty: 12.00		Customer:		
Reference:				

Approvals:	Process Plan: <u>mk</u>	Date: <u>09-08-13</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3508	Rev C								(PB) →

100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
	1-Cut as per Dwg D3508		<input checked="" type="checkbox"/> Dwg Rev: <u>C</u>	<input type="checkbox"/> Prog Rev: <u>C</u>	<input type="checkbox"/> 2-				
	Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
	Quality Control								

120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
	Quality Control								

⇒ 8/21/09/17

HB 9-8-13
 (12) \$ (12) →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3508-1 PAR #: _____ Fault Category: Small Fab NCR: Yes No DQA: / Date: 05-05-10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05-05-10

NCR: <u>51261</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/17	# 100	Qty 41 wear plate has the hole location on face to end too far to the edge edge the more while there were	<u>AS1412</u>	Scrap & destroy - be replace.	<u>B</u> 9-8-17	<u>C</u> 09/06/17	<u>AS1412</u>	<u>C</u> 09/06/17
		Jet was cutting the outside Profile R.C. process.	<u>AS1412</u>				<u>AS1412</u>	<u>S</u> 09/06/17

NOTE: Date & initial all entries

Work Order ID 51261

August 13, 2009 8:04:23 AM



Page 2

Item ID: D3508-1

Accept



Setup Start



Revision ID: C

Item Name: Wearplate

Stop



Start Date: 08/13/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

JB 09/08/20

12

/

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ S 07/09/31

410

/

Quality Control

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 2:00PM FINISH TIME: 2:30PM

□ OVEN TEMPERATURE: 320°F

⇒ JB 07/09/02

V12

/

Powder Coating

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 51261

August 13, 2009 8:04:23 AM



Page 3

Item ID: D3508-1

Accept



Setup Start



Revision ID: C

Item Name: Wearplate

Stop



Start Date: 08/13/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

2> 8/09/09/02



QC

Memo

0.00

(42)

f

Quality Control

170

Identify as per dwg & Stock Location

0.00

9/09/09/02



Packaging

Memo

0.00

2/2 0

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/03

Quality Control

u 9/24/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 13, 2009 8:04:23 AM

Page 1

Work Order ID: 51261



Parent Item: D3508-1RevC



Parent Item Name: Wearplate



Start Date: 08/13/2009

Required Date: 08/28/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	71.0990	2.9937	13		
304/316 .040 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

71.09904737

110076

31.73

111571

39.3690474

111571 B 9-8-13

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51261
Description: Wearplate		Part Number: D3508-1
Inspection Dwg: D3508	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.733	+/-0.010	2.808	X			
2.063 ✓	+/-0.010	2.064	*			
0.375 ✓	+/-0.010	.375	*			
5.800 ✓	+/-0.010	5.798	X			
11.600 ✓	+/-0.010	11.600	X			
Ø0.188 ✓	+0.005/-0.001	.190	*			
0.300 ✓	+/-0.010	.303	*			
0.300	+/-0.010	N/A .304	X			
0.038 ✓	+/-0.010	.038	X			

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 9-8-13	Date: 09/08/13	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.04.20	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

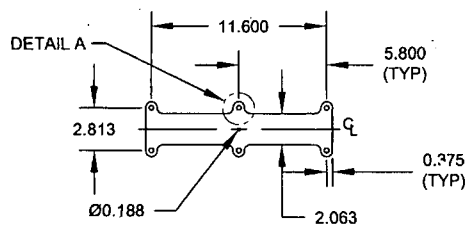
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Resolution: _____ Disposition: _____ QA: ☒ N/C ☐ Closed: _____ Date: _____

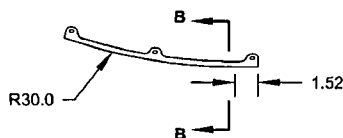
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

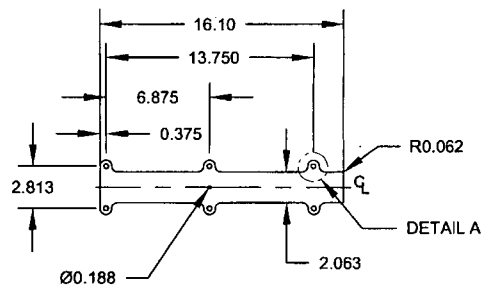
#51261 MF 09-08-13



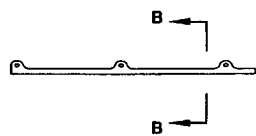
D3508-1 FLAT PATTERN



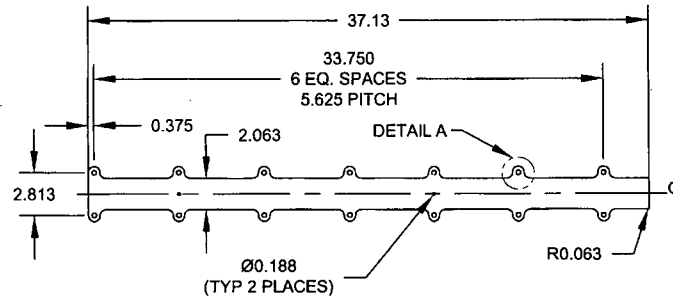
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



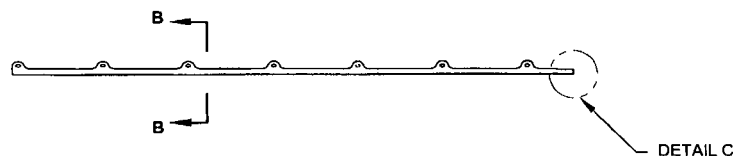
D3508-7F FLAT PATTERN



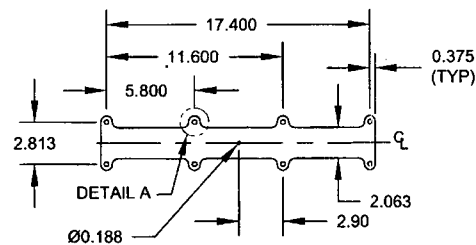
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



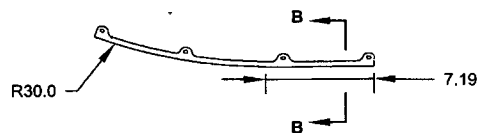
D3508-3 FLAT PATTERN



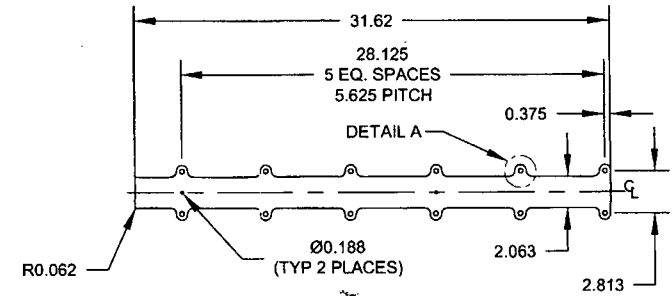
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



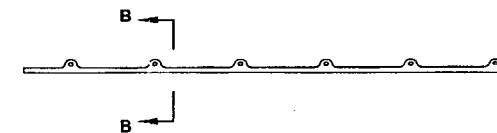
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

RELEASED
07-11-16

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. C
CHECKED	<i>[Signature]</i>	D3508	SHEET 1 OF 2
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	WEARPLATE	1:8
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	07.04.20		

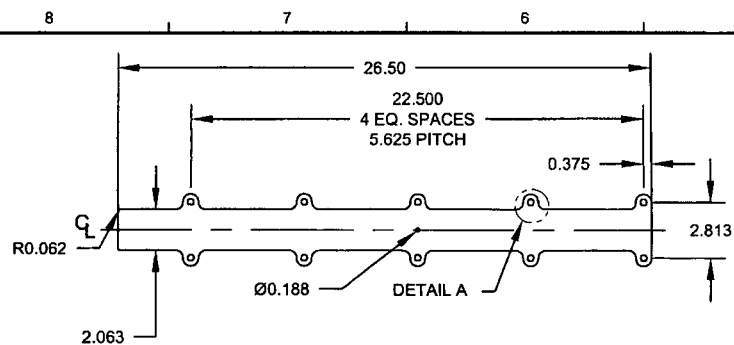
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

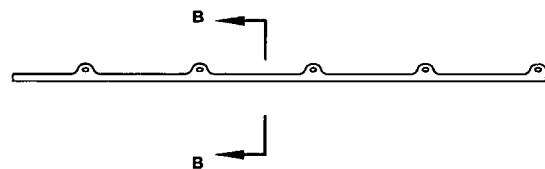
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

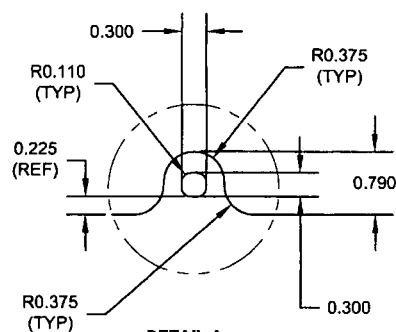
NOTE: Date & initial all entries



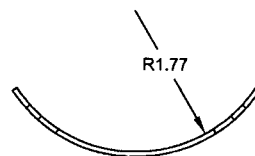
D3508-11F FLAT PATTERN



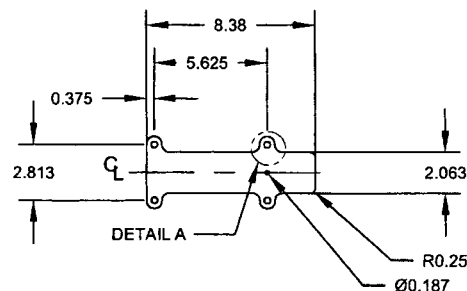
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



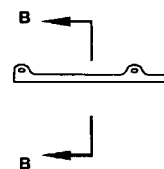
DETAIL A
(SCALE 2:3)



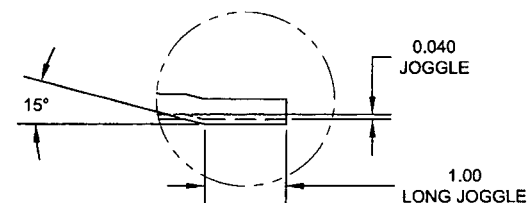
SECTION B-B
(SCALE 2:3)



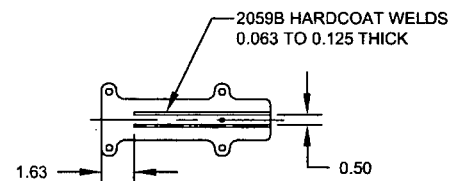
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

51261

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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